

(19)

Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 1 065 161 A2

(12)

EUROPEAN PATENT APPLICATION

(43) Date of publication:
03.01.2001 Bulletin 2001/01

(51) Int. Cl.⁷: B65H 20/02, B65H 23/182,
B65H 23/188

(21) Application number: 00108627.1

(22) Date of filing: 20.04.2000

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE

Designated Extension States:
AL LT LV MK RO SI

(30) Priority: 29.06.1999 JP 18350099

(71) Applicant:
Miyakoshi Printing Machinery Co., Ltd.
Narashino-shi, Chiba-ken 275 (JP)

(72) Inventors:
• Kishine, Toshiaki,
Soleil Takanodal A-203
• Chiba-shi, Chiba (JP)
• Ishikawa, Akira
Kamagaya-shi, Chiba (JP)
• Ito, Takashi
Inba-gun, Chiba (JP)

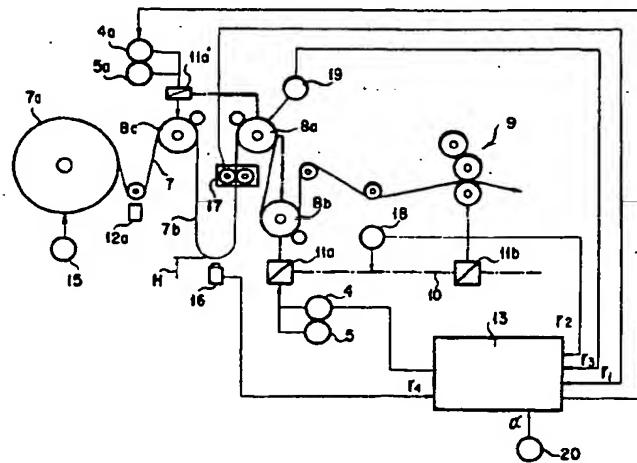
(74) Representative:
Fuchs Mehler Weiss & Fritzsche
Patentanwälte
Postfach 46 60
65036 Wiesbaden (DE)

(54) Infeed system of rotary press

(57) In a rotary press, a traveling amount of a paper web (7) is controlled by an infeed system including infeed rolls (8c, 8a), by which the paper web is fed to a subsequent stage for such as printing process. The infeed system of the rotary press includes traveling amount measuring device disposed on a traveling line of a paper web travelled by the infeed rolls for measur-

ing a traveling amount (17) of the paper web under a tension free state and generating a signal representing the measured result, and a traveling amount controlling device (13) for controlling the traveling amount of the paper web fed by the infeed rolls in response to the signal from the traveling amount measuring means.

FIG. 1



Description

BACKGROUND OF THE INVENTION

[0001] The present invention relates to an infeed system of a rotary press in which a paper web of a web roll supported by a web roll supporting means of a rotary press is supplied for a succeeding process such as a printing process in a printing section by means of infeed roll by which a paper web traveling amount can be controlled.

[0002] In a case where a plurality of paper webs printed by a rotary press are gathered or collated by a collator, it is required for the paper webs to have the same top and bottom dimensions with each other. Particularly, for a business-form rotary press carrying out printings on paper webs which are required to be gathered or collated by the collator after printings, it is very important for the paper webs to have constant top and bottom dimensions with each other even if materials, basis weights thickness or the like of paper webs to be collated are different from each other.

[0003] However, as is known, where the paper webs are fed by an infeed system of the rotary press, the traveling amounts thereof differ from each other in accordance with the materials, basis weights thickness or the like of the paper webs. Accordingly, in a case where such various different kinds of paper webs are printed, the traveling amounts differ from each other even if the paper webs are printed under the same printing conditions, hence providing inconvenience at the time when paper webs are gathered or collated.

[0004] In order to eliminate such defects, a first prior art providing a solution is disclosed for example, in Japanese Patent Publication No. HEI 4-51456. This prior art discloses a structure, as shown in Fig. 2, comprising a plate cylinder 1, a blanket (rubber) cylinder 2, an impression cylinder 3, and a differential speed change gear 5 disposed in a power transmission means for the blanket cylinder 2 and the impression cylinder 3 which put a paper web between them, carry out printing on the paper web and make the same travel. The differential speed changer 5 comprises a Harmonic Drive (Trade Name) a speed of which is adjustable by an adjustment motor 4. In this structure, the plate cylinder 1, the blanket cylinder 2 and the impression cylinder 3 are coupled in series to each other and rotated at the same rotation number in directions reverse to each other.

[0005] According to this first prior art, the rotating speed of the impression cylinder 3 is adjusted by the differential speed change gear 5 with respect to the rotating speed of the blanket cylinder 2 thereby to change the traveling amount of the paper web. That is, in a case of thick paper web, the rotating speed of the impression cylinder 3 is decreased, and on the other hand, in a case of thin paper web, the impression cylinder 3 is adjusted reversely. In this manner, the traveling amount

of the paper web can be changed.

[0006] A second prior art also provides a solution, in which the rotating speed of the infeed roll is adjusted in accordance with the change of the tensions in consideration that tensions of paper webs passing between rolls are changed in accordance with the change of the paper web thickness.

[0007] Fig. 3 is a schematic view showing the structure of the above second prior art. With reference to Fig. 3, a paper web 7 fed from a web roll 7a is fed in the paper web traveling direction and wound up in substantially S-shape around two infeed rolls 8a and 8b, which are rotated in directions reverse to each other at the same rotating speed, and the paper web 7 is then supplied on a side of the printing unit 9, i.e. downstream side, in the paper web traveling direction. The infeed rolls 8a, 8b and the printing unit 9 are driven by a drive line 10 from a press machine side through gear boxes 11a and 11b, respectively. In the gear box 11a driving the infeed rolls 8a and 8b, there is housed the differential speed change gear 5 having the speed ratio (gear ratio) which is adjustable by the adjusting motor 4 as like as in the first prior art mentioned above. Further, first and second tension detectors 12a and 12b for detecting the tension of the paper web 7 are arranged on both the upstream side and downstream side of the infeed rolls 8a and 8b, respectively.

[0008] In Fig. 3, reference numeral 13 denotes a controller for generating a speed change signal to the motor 4. The controller 13 carries out a comparison operation of a detection value T1 fed back from the second tension detector 12b disposed downstream side of the infeed rolls 8a and 8b with a set value T2 preset by a setting device 14, and the controller 13 then generates a signal, to the motor 4, for adjusting the differential speed change gear 5 so as to rotate the infeed rolls 8a and 8b at the rotating speed at which the compared value becomes zero. Accordingly, the infeed rolls 8a and 8b are controlled so that the tension T1 of the paper web 7 detected by the second tension detector 12b always becomes equal to the set value T2 set by the setting device 14 thereby to keep constant the traveling amount of the paper web 7. Further, reference numeral 15 denotes a brake means operating in response to the detection value detected by the first tension detector 12a.

[0009] Further, it is to be noted that the term "traveling amount" used herein means a traveling distance (length) per unit rotation number of a prime mover (motor) of the rotary press, a traveling distance (length) per one rotation of the infeed roll or a traveling distance (length) per unit time.

[0010] In the first prior art mentioned above, when paper webs having different thicknesses are fed by the blanket cylinder 2 and the impression cylinder 3 as the infeed rolls with the tension applied to the paper web in the paper web traveling line and being maintained constant, the traveling amount of the paper webs differ in

accordance with the thicknesses of the paper webs. Because of this reason, in the prior art, in order to make constant the traveling amounts of a plurality of paper webs having different thicknesses, it is necessary to obtain an aimed (target) traveling amount of the paper web by experimentally calculating a preset value to be inputted into the adjusting motor 4 for determining the speed ratio (gear ratio) of the differential speed change gear 5 with respect to each of the paper webs, measuring an absolute value of the paper web traveling amount by means of scale and so forth, in an operation stop condition of the printer, and then amending or correcting a feed amount by the infeed roll. Accordingly, it is very difficult to make travel the plurality of paper webs having different thicknesses at the same traveling amount. Furthermore, because the wind-up diameter of the web roll is changed as the paper web is fed, it is sometimes necessary to check the traveling amount at an intermediate time of the feeding as well as the feed-start time according to the condition of the web. In such case, some problems were caused on the printing process.

[0011] On the other hand, in the second prior art mentioned above, the detection value T1 and the set value T2 are compared by the controller 13, and the signal for operating the adjustment motor 4 to adjust the motor rotating speed so as to make zero the compared value is generated to the motor 4. According to this operation, the tension of the paper webs having different thicknesses at the traveling time can be made constant and the traveling speed of the paper webs can be hence maintained constant.

[0012] However, the detection value T1 inputted into the controller 13 is a value of the tension, which is a predetermined tension applied to the paper web 7, and therefore, this value T1 is the value detected at time when the paper web is elastically and plastically deformed by the tension. Accordingly, even if the detection value T1 is the same with respect to the different paper webs, the actual traveling amounts of the paper webs having different thicknesses and different elastic deformations due to the thickness difference, become different from each other. Thus, the correction or amendment of this matter is very troublesome to be handled.

[0013] In an actual operation, in order to obtain a precise traveling amount of the paper web, it is necessary to actually measure the absolute value of the paper web traveling amount by means of a scale or the like after once stopping the feeding of the paper web and then to correct and preset the set value T2 of the tension in conformity with the measurement result of the absolute value of the traveling amount. These workings are made in accordance with the experience of the workers, requiring the skill and, hence, being troublesome and inconvenient. That is, in such a prior art, it is difficult to carry out the presetting of the fundamental traveling amount.

SUMMARY OF THE INVENTION

[0014] An object of the present invention is to substantially eliminate defects or drawbacks encountered in the prior art mentioned above and to provide an infeed system of a rotary press capable of accurately measuring an absolute value of traveling amount of a paper web regardless of material, basis weight (thickness) or the like of the paper web, always maintaining the traveling amount thereof to an aimed (target) traveling amount and making constant the traveling amount of the paper web in conformity with gathering or collating operation of a collator.

[0015] This and other objects of the present invention can be achieved by providing, in one aspect, an infeed system of a rotary press in which a traveling amount of a paper web is controlled by an infeed roll, by which the paper web is fed for a subsequent process, comprising:

20 a traveling amount measuring means disposed on a traveling line of a paper web travelled by the infeed roll for measuring a traveling amount of the paper web under a tension free state and generating a signal representing the measured result; and a traveling amount controlling means for controlling the traveling amount of the paper web fed by the infeed roll in response to the signal from the traveling amount measuring means.

[0016] In a more concrete aspect, there is provided an infeed system of a rotary press for controlling a traveling amount of a paper web fed from a web roll, comprising:

35 at least first and second two infeed rolls disposed downstream side of the web roll to be rotatable in the same direction for feeding the paper web downstream side in a traveling direction thereof in the tension free state between the first and second rolls;

40 an infeed roll driving means for driving the infeed rolls and including infeed roll rotation speed adjusting means, respectively;

45 a traveling amount detection means for detecting a paper web traveling amount and generating a signal for the detection value;

50 a rotation speed detection means for detecting a rotation speed of the infeed rolls and generating a signal for the detection value; and

55 a control means operatively connected to the infeed roll driving means, the traveling amount detecting means and the rotation speed detection means for controlling the traveling amount of the paper web in response to the signals of the detection value of the traveling amount and the detection value of the rotation speed.

[0017] In a more specific embodiment, the infeed system further comprises a third roll disposed downstream side of the second roll to be rotatable in a direction reverse to that of the second roll.

[0018] According to the infeed system of the rotary press of the present invention mentioned above, the amount of traveling the paper web from the web (roll) to the subsequent stage or process such as printing process is measured under the no-tension (tension free) state on the paper web traveling line by the traveling amount detector, and accordingly, the traveling amount measured under this state can be measured as an absolute value with no relation to the material of the paper web and the basis weight thickness thereof. The thus measured value is compared with the target traveling amount thereby to control the traveling amount of the paper web of the infeed rolls by the control means.

[0019] The traveling amount of the paper web by means of infeed rolls can be mechanically controlled in accordance with the traveling amount of the paper web under the tension free state, and accordingly, in a case where paper webs different in their materials, basis weights or thicknesses and the like are fed, the traveling amount of the paper webs can be always maintained substantially to the target traveling amount and the collation by the collator can be made properly constant.

[0020] Furthermore, it is not necessary to carry out the measurement or correction of the traveling amount by stopping the operation of a machine at every time when a different paper web is used, thus eliminating loss of working time, being convenient and advantageous.

[0021] The nature and further characteristic features of the present invention will be made more clear from the following descriptions made with reference to the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[0022] In the accompanying drawings:

Fig. 1 is a schematic diagram showing a structure and arrangement of an infeed system of a rotary press according to one embodiment of the present invention;

Fig. 2 is a schematic sectional view of one conventional structure of an infeed system of a rotary press; and

Fig. 3 is a schematic diagram showing another conventional structure of an infeed system of a rotary press.

DESCRIPTION OF THE PREFERRED EMBODIMENT

[0023] One preferred embodiment of the present invention will be described hereunder with reference to Fig. 1, in which the same reference numerals used in

Figs. 2 and 3 are added to corresponding elements or arrangements, respectively.

[0024] With reference to Fig. 1, in addition to the first and second infeed rolls 8a and 8b in the conventional arrangement, a third infeed roll 8c is arranged. This third infeed roll 8c is positioned on the upstream side of the paper web feed direction of the infeed rolls 8a and 8b at a position separated by a predetermined distance from the first infeed roll 8a in the traveling direction of the paper web 7 so as to be rotatable in the same direction of the first infeed roll 8a.

[0025] The third infeed roll 8c is operatively connected to the first gear box 11a, which is the driving source common to that of the first and second infeed rolls 8a and 8b, through a transmission mechanism having the same speed ratio (gear ratio) as that of the infeed rolls 8a and 8b. A rotation speed of an output side of the first gear box 11a is made optionally adjustable by means of the differential speed change gear 5 having the rotational speed which is adjustable by the motor 4 as in the second prior art mentioned hereinbefore.

[0026] Furthermore, in the transmission mechanism connecting the third infeed roll 8c and the first gear box 11a, another gear box 11a' which houses another differential speed change gear 5a having a rotational speed adjustable by another adjusting motor 4a connected to the controller 13 are incorporated so that the rotating speed of the third infeed roll 8c can be solely adjusted independently of the first and second infeed rolls 8a and 8b.

[0027] A paper web detector 16, such as ultrasonic sensor, for detecting the traveling paper web 7 is disposed at a position sufficiently below the portion between the first and third infeed rolls 8a and 8c which are rotatable in the same direction, the paper web detector 16 being directed upward, as viewed. And a paper web traveling amount detector 17 for detecting the traveling amount of the paper web 7 is arranged upstream side of the first infeed roll 8a. The paper web traveling amount detector 17 comprises, for example, a pair of rolls which are rotatable without slipping and an encoder detecting the rotational speed of these rolls.

[0028] Further, the first and second gear boxes 11a and 11b are connected with a drive line 10 on which a drive line rotation speed detector 18 is arranged, and an infeed roll rotation speed detector 19 is also arranged on one of the first and second infeed rolls 8a and 8b so as to detect the rotating speed thereof. These detectors 17, 18 and 19 are operatively connected to the controller 13 so that the detected values r1, r2 and r3 of these detectors are inputted to the controller 13.

[0029] The controller 13 is provided with a setting device 20, and information of the material, basis weight (thickness) and the like of the paper web 7 are inputted into the setting device 20 and, according to these information, there is determined an initial feed amount of the paper web 7 with respect to the target traveling amount thereof, which is then inputted into the controller 13 as

the initially set feed amount α .

[0030] In the structure mentioned above, the paper web 7 taken out from the web roll 7a is fed to the printing unit 9 side through the third, first and second infeed rolls 8c, 8a and 8b, which are arranged in this order from upstream side to the downstream side of the paper web traveling direction. The paper web 7 of the web roll 7a is taken out by the third infeed roll 8c disposed most upstream side.

[0031] In this paper web feeding process, the above three infeed rolls 8c, 8a and 8b are rotated at the same speed by means of the drive line 10 and the gear box 11a. The rotation speed of the rolls at this time is controlled by the differential speed change gear 5 which is adjusted by the adjusting motor 4 thereby to finely adjust the traveling amount of the paper web 7.

[0032] As mentioned above, in this paper web feeding process, since the third roll 8c and the first roll 8a are rotated at the same speed, no tension is applied to the paper web 7 (tension free state) between these rolls 8c and 8a; so that a loop portion 7b of the paper web 7 suspended downward is formed between these rolls 8c and 8a as shown in Fig. 1. Then, the paper web 7 in this loop portion 7b is passed through the traveling amount detector 17. The paper web 7 passing through the traveling amount detector 17 is pulled by the first infeed roll 8a disposed downstream side of the third infeed roll 8c; and then, the roller of the traveling amount detector 17 is rotated thereby to detect the traveling amount of the paper web portion to which no tension is applied (no-tension or tension free portion). The thus detected signal r1 is inputted into the controller 13.

[0033] With reference to Fig. 1, a height H, as viewed, of the loop portion 7b of the paper web 7 between the rolls 8c and 8a is detected by the paper web detector 16, and the detected value (signal) r4 is inputted into the controller 13. The height H of the loop portion 7b is changed in response to the rotation speed of the third infeed roll 8c arranged upstream side the loop portion 7b. Further, since it is desired for the height H of the loop portion 7b to be always constant, this height H is adjustable to be always constant by finely adjusting the rotation speed of the third infeed roll 8c by the differential speed change gear 5a which is controlled by the controller 13 via the adjusting motor 4a of in response to the signal corresponding to the detected value r4 by the paper web detector 16.

[0034] The initially set feed amount α to the target traveling amount of the paper web 7 set in accordance with the paper web material, basis weight (thickness) and the like of the paper web 7 is preset in the controller 13 by means of the setting device 20. Then, the controller 13 operates to compare the initially set feed amount α with the traveling amount of the loop portion of the paper web 7 calculated from the detection signal r3 from the infeed roll rotation speed detector 19, to calculate a differential feed amount between the traveling amount of the paper web and the initially set feed amount α , that

is, a feed amount for converting the traveling amount, and then to generate a correction signal for correcting the traveling amount of the paper web 7 so as the differential feed amount becomes zero to the adjusting motor 4 of the gear box 11a. This correction signal is generated until the traveling amount of the loop portion 7b of the paper web 7 accords with the initially set feed amount α . After the completion of the initial setting, the transmission of the correction signal of the first gear box 11a from the controller 13 to the adjusting motor 4 is stopped.

[0035] As mentioned above, by presetting the initially set feed amount α , the traveling amount of the paper web nearly the target traveling amount can be obtained at the initial stage, and hence, an amount of the wastepaper web generating at the operation starting time can be substantially reduced.

[0036] In the next step, the target traveling amount calculated from the signal r2 of the driving line rotation speed detector 18 and the absolute value of the traveling amount measured by the traveling amount detector 17 are compared by the controller 13 thereby to calculate a differential feed amount between the traveling amount and the target traveling amount. Then, the correction signal for correcting the traveling amount is of the paper web 7 so as to the differential feed amount becomes zero is outputted to the adjusting motor 4 of the first gear box 11a.

[0037] That is, in the case where the traveling amount of the paper web 7 by means of the infeed rolls 8a, 8b and 8c is greater than the target traveling amount, a signal for decreasing (reducing) the paper web traveling amount is outputted to the adjusting motor 4, and on the other hand, in the case where the traveling amount of the paper web 7 by means of the infeed rolls 8a, 8b and 8c is smaller than the target traveling amount, a signal for increasing the paper web traveling amount is outputted to the adjusting motor 4, thus maintaining the paper web traveling amount always constant to the target traveling amount.

[0038] The tension of the paper web 7 fed from the web 7a is detected by the tension detector 12a disposed at the predetermined position, and in response to the detected value, the operation of the brake 15 is adjusted.

[0039] It is to be noted that the present invention is not limited to the described embodiment and many other changes and modifications may be made without departing from the scopes of the appended claims.

[0040] For example, the traveling amount detector 17, mentioned above, comprising a pair of rolls and an encoder may be substituted with a non-contact type detector. Moreover, in order to create no tension to the paper web 7, at least two infeed rolls may be required, and in this meaning, the most downstream side infeed roll 8b may be eliminated.

[0041] Although the present invention has been hereinbefore described very specifically and as adapted

for a rotary printing press, it is not desired that the invention is limited by the exact details of this disclosure. A variety of modifications and alterations of the illustrated embodiments may be made in order to conform to design preferences or to the requirements of each specific application, without departing from the proper scope or fair meaning of the claims which follows.

Claims

1. An infeed system of a rotary press in which a traveling amount of a paper web (7) is controlled by an infeed roll (8c,8a), by which the paper web is fed to a subsequent process, characterized in that a traveling amount of the paper web is measured by a traveling amount measuring device (17) disposed on a traveling line of the paper web travelled by the infeed roll under a tension free state and adapted to generate a signal representing the measured result, and the traveling amount of the paper web is controlled by a controlling device (13) in response to the signal from the traveling amount measuring device. 10

2. An infeed system of a rotary press for controlling a traveling amount of a paper web (7) fed from a web roll (7a) characterized by comprising: 25

at least first and second two infeed rolls (8c,8a) disposed downstream side of the web roll to be rotatable in the same direction for feeding the paper web in a traveling direction thereof in the tension free state between the first and second rolls; 30

a driving device (10,11a,4,5) for driving the infeed rolls and adjusting the infeed roll rotation; a traveling amount detection device (17) for detecting a traveling amount of the paper web and generating a signal for the detected value; 35

a rotation speed detection device (19) for detecting a rotation speed of the infeed rolls and generating a signal for the detection value; 40

and

a control device (13) operatively connected to said driving device, said traveling amount detection device and said rotation speed detection device for controlling the traveling amount of the paper web in response to the signals of the detection value of the traveling amount and the detection value of the rotation speed. 45

3. An infeed system of a rotary press according to claim 2, characterized in that a third roll (8b) disposed downstream side of the second roll to be rotatable in a direction reverse to that of the second roll. 50

55

FIG. 1

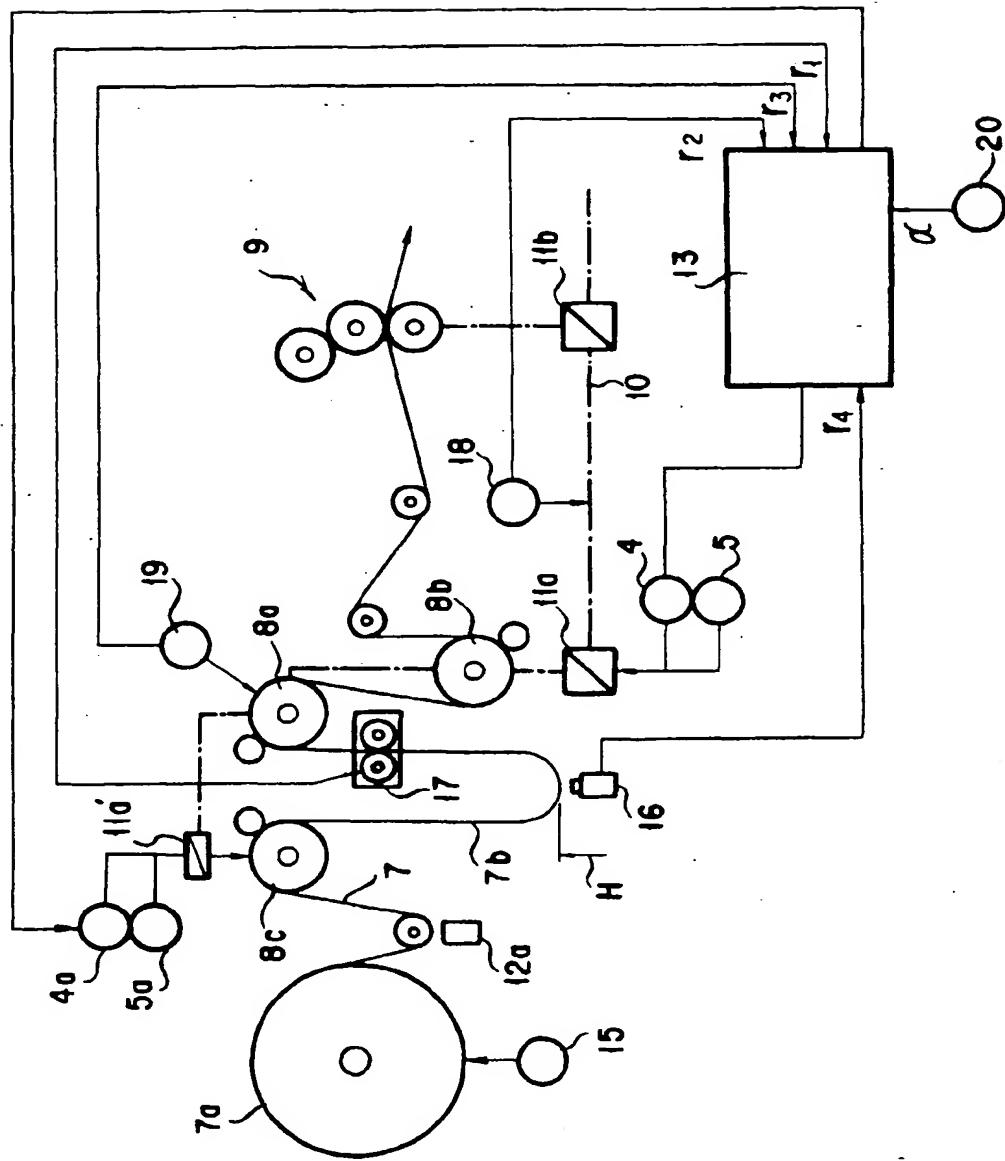


FIG. 2

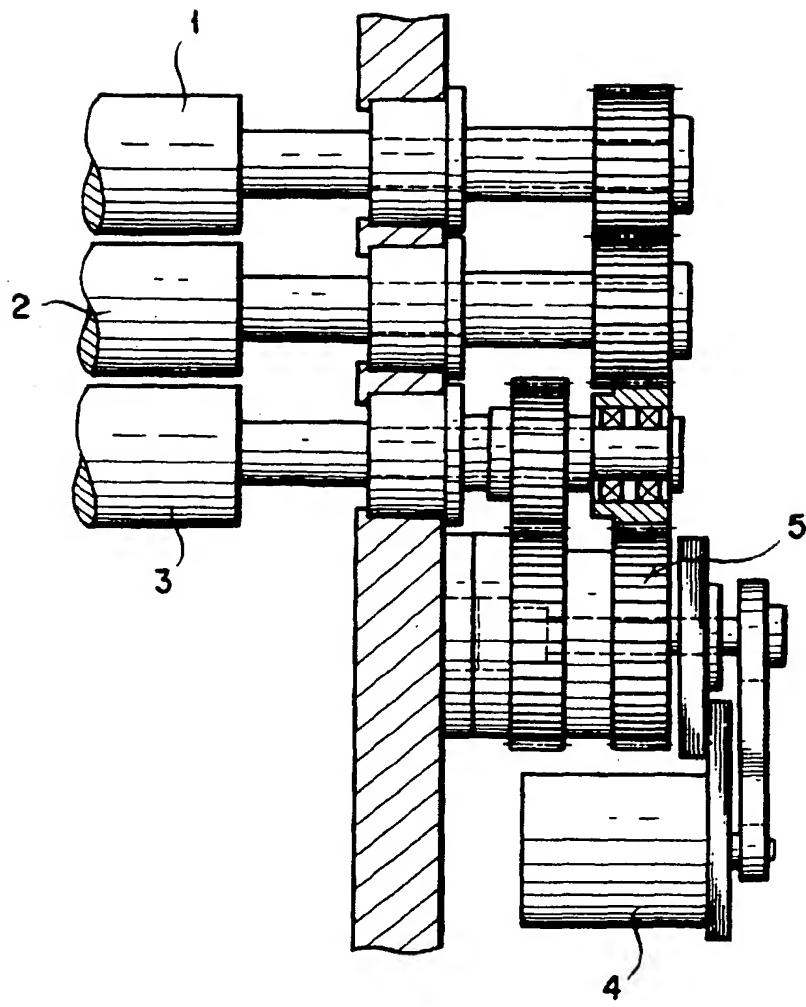
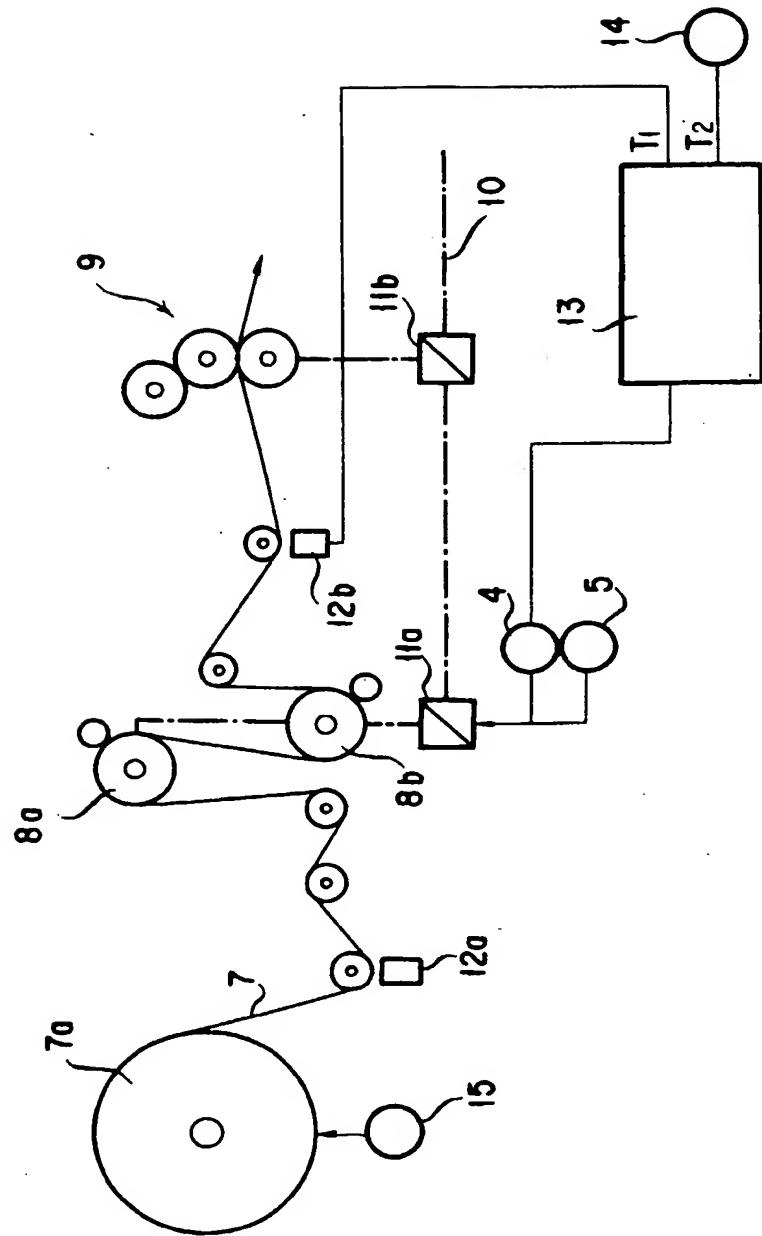


FIG. 3



THIS PAGE BLANK (USPTO)

THIS PAGE BLANK (USPTO)

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11)

EP 1 065 161 A3

(12)

EUROPEAN PATENT APPLICATION

(88) Date of publication A3:
05.03.2003 Bulletin 2003/10

(51) Int Cl.7: B65H 20/02, B65H 23/182,
B65H 23/188

(43) Date of publication A2:
03.01.2001 Bulletin 2001/01

(21) Application number: 00108627.1

(22) Date of filing: 20.04.2000

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE

Designated Extension States:
AL LT LV MK RO SI

(30) Priority: 29.06.1999 JP 18350099

(71) Applicant: Miyakoshi Printing Machinery Co., Ltd.
Narashino-shi, Chiba-ken 275 (JP)

(72) Inventors:

- Kishine, Toshiaki, Soleil Takanodai A-203
Chiba-shi, Chiba (JP)
- Ishikawa, Akira
Kamagaya-shi, Chiba (JP)
- Ito, Takashi
Inba-gun, Chiba (JP)

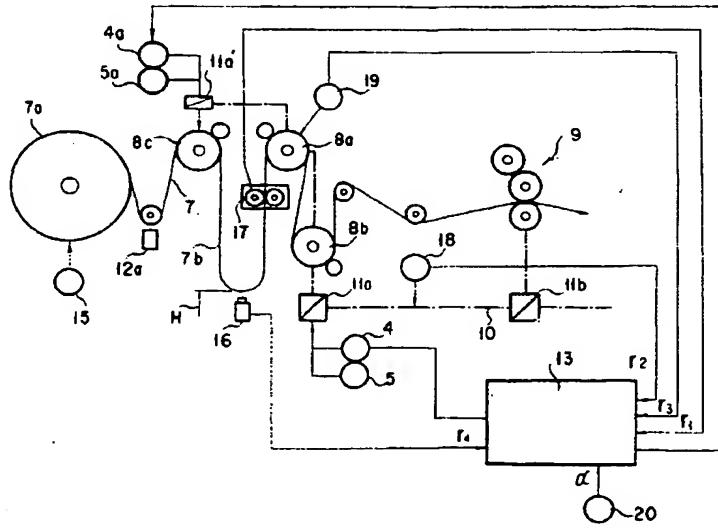
(74) Representative: Fuchs Mehler Weiss & Fritzsche
Patentanwälte
Postfach 46 60
65036 Wiesbaden (DE)

(54) Infeed system of rotary press

(57) In a rotary press, a traveling amount of a paper web (7) is controlled by an infeed system including infeed rolls (8c,8a), by which the paper web is fed to a subsequent stage for such as printing process. The infeed system of the rotary press includes traveling amount measuring device disposed on a traveling line

of a paper web travelled by the infeed rolls for measuring a traveling amount (17) of the paper web under a tension free state and generating a signal representing the measured result, and a traveling amount controlling device (13) for controlling the traveling amount of the paper web fed by the infeed rolls in response to the signal from the traveling amount measuring means.

FIG. 1





European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 00 10 8627

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (IntCl.7)						
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim							
X	US 4 057 185 A (SLAMA JERRY L ET AL) 8 November 1977 (1977-11-08) * column 4, line 10 - line 34; figures * ---	1, 2	B65H20/02 B65H23/182 B65H23/188						
X	EP 0 822 155 A (REYNOLDS TOBACCO CO R) 4 February 1998 (1998-02-04) * column 3, line 28 - column 4, line 26 * * column 5, line 27 - line 29; figure 1 * ---	1							
X	EP 0 721 906 A (TETRA LAVAL HOLDINGS & FINANCE) 17 July 1996 (1996-07-17) * column 3, line 13 - column 4, line 20; figures * ---	1							
X	US 5 785 226 A (DREW WILBUR ET AL) 28 July 1998 (1998-07-28) * the whole document * ---	1							
A	DE 32 27 567 A (SCHOEN & CIE GMBH) 26 January 1984 (1984-01-26) ---								
A	PATENT ABSTRACTS OF JAPAN vol. 017, no. 080 (M-1368), 17 February 1993 (1993-02-17) & JP 04 280762 A (TOSHIBA CORP), 6 October 1992 (1992-10-06) * abstract * -----		TECHNICAL FIELDS SEARCHED (IntCl.7) B65H						
<p>The present search report has been drawn up for all claims</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Place of search</td> <td style="width: 33%;">Date of completion of the search</td> <td style="width: 34%;">Examiner</td> </tr> <tr> <td>THE HAGUE</td> <td>9 January 2003</td> <td>Lemmen, R</td> </tr> </table> <p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>				Place of search	Date of completion of the search	Examiner	THE HAGUE	9 January 2003	Lemmen, R
Place of search	Date of completion of the search	Examiner							
THE HAGUE	9 January 2003	Lemmen, R							

ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.

EP 00 10 8627

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on. The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

09-01-2003

Patent document cited in search report		Publication date	Patent family member(s)		Publication date
US 4057185	A	08-11-1977	NONE		
EP 0822155	A	04-02-1998	US	5709352 A	20-01-1998
			EP	0822155 A2	04-02-1998
			JP	10081438 A	31-03-1998
EP 0721906	A	17-07-1996	SE	502837 C2	29-01-1996
			AT	195109 T	15-08-2000
			AU	699990 B2	17-12-1998
			AU	4089296 A	18-07-1996
			CA	2166908 A1	12-07-1996
			DE	69518219 D1	07-09-2000
			DE	69518219 T2	14-12-2000
			DK	721906 T3	04-09-2000
			EP	0721906 A1	17-07-1996
			ES	2149311 T3	01-11-2000
			JP	8225201 A	03-09-1996
			RU	2156217 C2	20-09-2000
			SE	9500077 A	29-01-1996
			US	5707024 A	13-01-1998
US 5785226	A	28-07-1998	NONE		
DE 3227567	A	26-01-1984	DE	3227567 A1	26-01-1984
JP 04280762	A	06-10-1992	JP	3164594 B2	08-05-2001

THIS PAGE BLANK (USPTO)